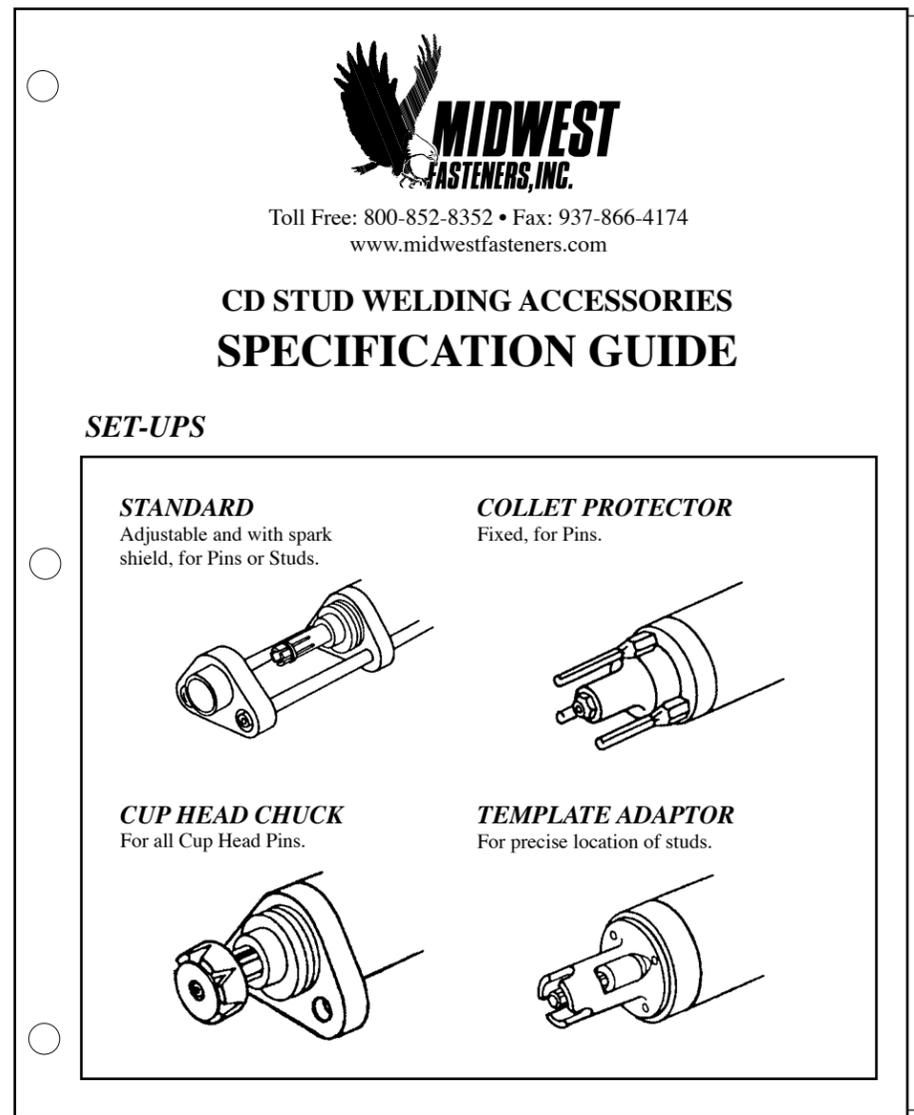


The chart settings shown below are “reference” settings to be used as starting points. Actual voltage settings may vary depending upon the conditions or each application and use.

Pin/Stud Type	Pin/Stud Dia	Pin/Stud Mat'l.	Voltage Setting
Insulation Pin	12 GA	Mild Steel	75-85
	10 GA	or Stainless	85-95
Weld Studs (Flanged)	12 GA	Aluminum	110-120
	10 GA		120-130
	#10 or 3/16"	Mild Steel or Stainless	120-130
	1/4"		145-155
#8	Aluminum	120-130	
#10 or 3/16"		130-140	

## VOLTAGE SETTINGS

for ACCESSORIES  
and SPARE PARTS  
see:



Solid State – Capacitor Discharge  
**Pin Welding System**

# Quick Startup Guide

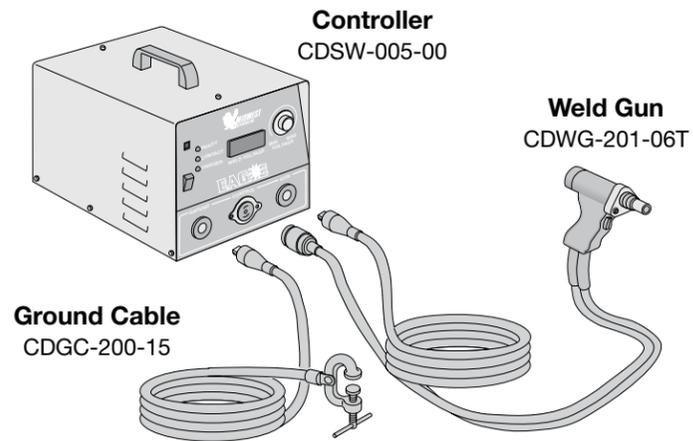




MIDWEST FASTENERS INC.

### PARTS

#### Eagle Components

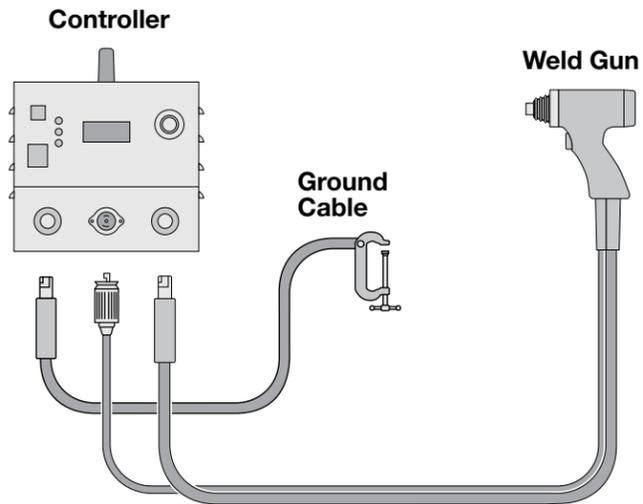


Remove the controller, cables and weld gun from the shipping packaging.

Connect the Cable connectors to the controller as marked: "GROUND" or "GUN".

### SETUP

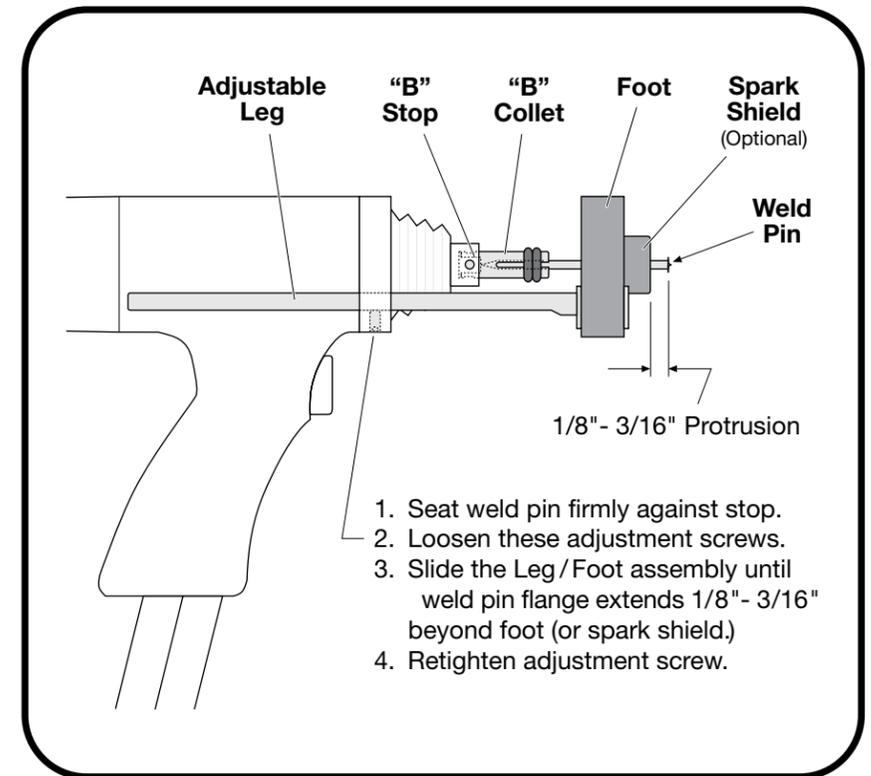
#### Eagle Cable Connections



**NOTE:** All cables should be laid out straight or in a random fashion.

### CD-2 WELD GUN SETUP

#### WELD PINS



### CD-2 WELD GUN SETUP

#### INSULATION PINS WITH COLLET PROTECTOR

